Wednesday, 3/26/2008 10:02:16 AM

Julie Lecocq

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 38192

Estimate Number

: 11160

P O Number

: 3/26/2008

This Issue Prsht Rev.

. NC

: 32827

Type

S.O. No. :

: MACHINED PARTS

Part Number **Drawing Number** 

**Drawing Name** 

: D32571 D3257 REV A1

Project Number Drawing Revision

: N/A

Material

**Due Date** 

: 4/5/2008

: FITTING

Qtv:

6 Um:

Each

Written By

First Issue

Previous Run

Checked & Approved By

Comment

Α 04.04.14

New issue KJ/RF

Additional Product

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M303B0500X0500

AISI 303 Bar .5 x .5

Comment: Qty.:

0.1147 f(s)/Unit Total:

0.6880 f(s)

AISI 303 Bar .5 x .5

Material: AISI 303 SS Bar (M303B0.500x0.500)

Identify for D3257-1

Batch:

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blank: 0.500" x 0.500" x 1.180" long Bar

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #7





Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA420 and Dwg D3257

Deburr

INSPECT PARTS AS THEY COME OFF

4.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



5.0

QC8

SECOND CHECK

\*. Comment: SECOND CHECK



08/04/06

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	·									
Part No	·	PAR #:	Fault Category:	NCR: Y	es No DC	QA:	Date: _			
				Q	A: N/C Close	ed:	Date: _			
NCR:			WORK ORDER NON-COM	IFORMANCE (N	CR)					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	NC Corrective Action Section B			Corrective Action Section B		Verification Appr	Approval	val Annual
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
	-									

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 10:02:16 AM User: Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: FITTING Job Number: 38192 Part Number: D32571 Job Number: Seq. #: Description: **Machine Or Operation:** 6.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock 5+80 -Location:\_ 7.0 QC21 18/04/08 Comment: FINAL INSPECTION/W/O RELEASE mr 08-04-07 Job Completion

Dart Ae	rospace	Ltd							
W/O:		· · · · · · · · · · · · · · · · · · ·	W	ORK ORDER CHANGE	S		<del> </del>		
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· ·				,					
Part No	·	PAR #:	Fault Cate	gory:					
			WODK ODD	ED NON CONFORMAN			a:	_ Date: _	
NCR:			WURK URD	ER NON-CONFORMAN	ICE (NCR	)			
DATE	STEP	Description of NC	Corrective Action Section			Verification	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
							1		
				·			· <del></del>		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38192
Description: Fitting	Part Number:	D3257-1
Inspection Dwg: D3257 Rev: A1		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.128	7			
0.135	+0.010/-0.007	0.129	V			
1.080	+/-0.010	1.083	<b>✓</b>			
0.330	+/-0.010	0.325	V			
0.385	+/-0.010	6.390				.8.
Ø0.191	+0.005/-0.000	\$ 0.191	/		Y	
R0.193	+/-0.010	RO.193	1		,	
0.887	+/-0.010	0.8865	~			
0.385	+/-0.010	0.385	V			"Frank"
0.192	+/-0.005	0.193	<b>V</b>			
Ø0.230 x 100°	+/-0.010	\$ .234 x 100	/			
0.135	+0.010/-0.007	0.129	· 🗸		,	
	·					
						i
		· .				

Measured by:	Audited by:	DIP	Prototype Approval:	N/A
Date: 08/04	04 Date:	08/04/04	Date:	N/A

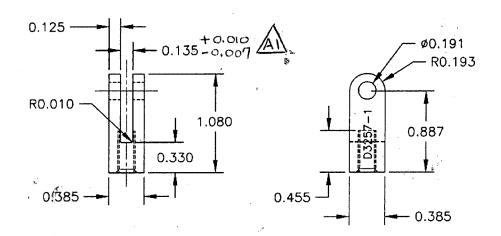
Rev	Date	Change	Revised by	Approved
Α	04.12.10	New Issue	KJ/JLM 1.	1
В	05.06.20	0.455 dimension removed	KJ/JLM	

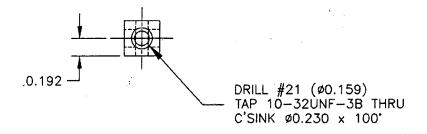




	DESIGN R	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO,	
	CHECKED	APPROVED	DRAWING NO.	REV. A
	#	#	D3257	SHEET 1 OF 1
	DATE		TITLE	SCALE
	04.01.27		FITTING	1:1
	A	04.01.27	NEW ISSUE	
ł	AL ALIA	- 04.12.14	ADD TOLERANCE	

# RELEASED





#### D3257-1 FITTING

NOTES:

1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015

- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

SHOP COPY

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RETURN TO

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SUBJECT TO AMENDINE

WORK ORDER

WORK ORDER

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